



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D5957
Job Sheet 180720



Part No: D5957

Job Qty: 1 ea

Part Name: Saddle



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/12/18

Job Tracking No:

Due Date: 7/13/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP Rev:E Re-Format 05-11-29 JLM IPP Rev:F ecn826 06.12.06 ec

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		7/13/18	0.00	0.00	Start Up Machining-4		SBL 18/07/12
100	CNC Vertical Machining	1 pcs		7/13/18	3.66	2.70	HAAS1-5		SBL 18/07/12
110	QC	1 pcs		7/13/18	0.00	0.00	QC1		SBL 18/07/12
120	QC	1 pcs		7/13/18	0.00	0.00	QC8 Machining-4		SBL 18/07/12
130	HandFinish	1 pcs		7/13/18	0.00	0.06	HandFinish1		SBL 18/07/12
140	Powdercoat	1 pcs		7/13/18	0.00	0.05	Powdercoat1		SBL 18/07/12
150	QC	1 pcs		7/13/18	0.00	0.00	QC3		JUL 24 2018
160	Packaging	1 pcs		7/13/18	0.00	0.00	Packaging3-2	51399	JUL 24 2018
170	QC21-SA	1 Ea		7/13/18	0.00	0.00	QC21		JUL 24 2018

Part Op 100 - 1-Machine as per folio D5957, Ensure Batch Number is entered

Descriptions: 110 - Inspect on CMM as per folio CMMA016

140 - START TIME

2.00 O.T: 3.00 FINISH: 3.00 M138839

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-007	Saddle Billet	1 Ea (1 ea)	90-Start up Operation	5069074 5091251

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6101-007	1	59	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS															
	Rework ☐	Scrap ☐	Use-as-is ☐	Suspected Unapproved ☐	Skid-tube ☐	Machining ☐	Thermoforming ☐	Large Fab ☐	Cross tube ☐	Small Fab ☐	Finishing ☐	Composite ☐	Water Jet ☐	Prod. Eng. Coord. ☐	Rec/Store/Packaging ☐	Supplier ☐	Engineering ☐	Quality ☐

Date: _____	Step #: _____	QTY Effective: _____	MRB (QS1042) Approval ☐
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Description Work Order	Completed By _____
	Lead hand / Supervisor _____
	Approval Verification _____
	QC / QA Coordinator Approval _____

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CANADA
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www.dartaerospace.com

Date: 07/12/10

DART AEROSPACE

Container No: S091252

Part: D5957
Job No: 180720
Serial No/Batch: S091252
Revision:
Inspector:
Exp Date:
Instructions:

Root Cause	
Environment	No Re-verification
Design	Operator
Doc/Data	Offset/Setup
Equip/Tooling	Supplier
Handling/Pre	Training
Material	Use for Testing
Internal Transport	Poor Information
Tribal Knowledge	Rushing
LOA	Product Improvement
Substation	Process Improvement
Past Expiry Date	Manufacturing Process
Misidentified	Past Due

OTHER: _____	Positioned Wrong ☐
	Outside Dimensions ☐
	Over/Under tolerance ☐
	Part Incorrect ☐
	Part Lost/Missing ☐
	Part Moved ☐
	Drawing ☐
	Finish ☐
	Misread ☐
	Turning Sequence ☐

DART AEROSPACE LTD		Work Order: 180720
Description: Inner Aft Saddle		Part Number: D5957
Inspection Dwg: D5957	Rev: B	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		0.438					
B	1.745	1.755		1.750					
C	5.245	5.255		5.250					
D	6.995	7.005		7.000					
E	5.240	5.260		5.250					
F	4.745	4.755		4.750					
G	0.315	0.322		0.316					
H	1.522	1.532		1.527					
I	3.048	3.058		3.052					
J	4.575	4.585		4.580					
K	0.315	0.322		0.316					
L	0.495	0.505		0.500					
M	0.490	0.510		0.499					
N	1.865	1.885		1.875					
O	7.990	8.010		8.000					
P	2.240	2.260		2.250					
Q	0.308	0.313		0.311					
R	0.760	0.765		0.760					
S	0.490	0.510		0.499					
T	1.625	1.645		1.625					
U	2.000	2.020		2.000					
V	0.023	0.043		0.033					
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: 57	Audited by: mmc
Date: 9-89 18/07/12	Date: 16/07/14

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF	
C	06.11.20	Added dimension V	KJ/JLM	
D	06.12.06	Dimensions L,N,P revised	KJ/EC	
E	07.06.15	Dimension G revised	KJ/JLM	
F	08.04.21	Dimension E revised	KJ/DD	
G	08.09.05	Dimension K revised	KJ/DD	
H	09.07.29	Dimension Q revised	KJ	